

# Work Order ID 77142

**\*77142\***

Page 1

November-25-11 3:15:36 PM

Item ID: D3916-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Light Rib  
 Start Date: 25/11/2011 Start Qty: 7.00 **\*7\*** Cust Item ID:  
 Required Date: 09/12/2011 Req'd Qty: 7.00 **\*7\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.J Date: 11/11/25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3916	A

100		0.00							
-----	--	------	--	--	--	--	--	--	--

**\*100\***  
 Large Fab  
 Large Fab  
 Memo  
 1- Cut tube 50"  
 2- Bend tube with manuel pipe bender as per DT9566  
 \*\*\* Make line at 9.00" annd use jig for other line\*\*\*  
 3- Trim access tube material to finish size as per dwg D3916

110	QC6- Inspect dimensions to drawing	0.00							
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**\*110\***  
 QC  
 Quality Control  
 Memo  
 121

120	Identify as per dwg & Stock Location: _____	0.00							
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**\*120\***  
 Packaging  
 Packaging  
 Memo  
 121

12 SAD 12-04-16

121 12-04-19

121 12-04-19

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

**\*77142\***

Page 2

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**\*7\***

**Cust Item ID:**

**\*7\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

**Insp.**  
**Stamp**

0.00


**\*130\***

QC

## Memo

0.00

## Quality Control

12/4/19 

1120419

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

# Picklist Print

November-25-11 3:15:40 PM

Page 1

Work Order ID: 77142

**\*77142\***

Parent Item: D3916-5

**\*D3916-5\***

Parent Item Name: Light Rib

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 7.00

Required Qty: 7.00

## Comments:

IPP RevA: new issue DD 09.11.23 verified by:EC  
as per dwg revA 10.03.15 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.500W.049

Purchased

No

100

f

667.9122

4.166

30.69684

**\*M304TS0 500W 049\***

Square Tubing

\*\*

SAD

12-04-10

## Location

MAT034

116610

117721

117999

118460

## Loc Qty

667.9121658

0.8383

0.3234

82.7504658

584

## Loc Code

M121328

49.9992

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W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

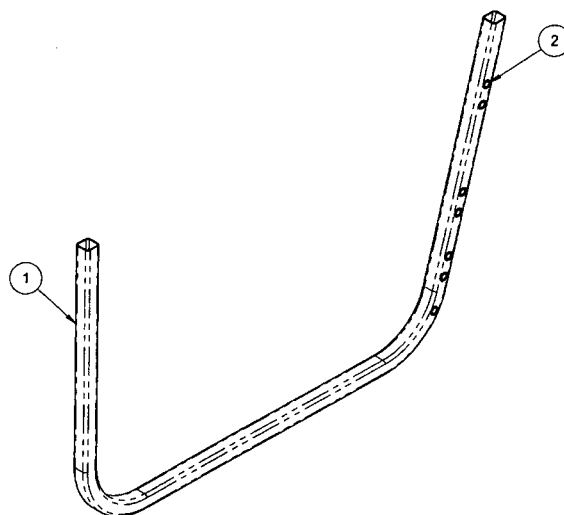
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

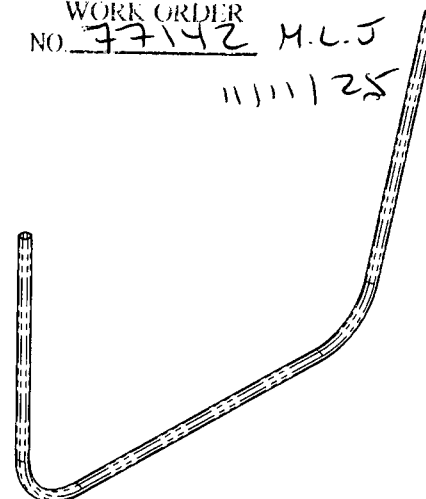
ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 77142 M.L.J

11/11/25



**D3916-041 RIB ASSY**



**D3916-5 LIGHT RIB**





OL 10.12.21  
**UNDER REVIEW**

10.10.1  
ADDITION OF HOLE + BUSHING  
ON D3916-041-1 RIBS.

**RELEASED**

2010-03-12

JNP

A	NEW ISSUE	JPH	10.03.04	
REV.		DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3916	SHEET 1 OF 4
APPROVED			TITLE	SCALE
DE APPR.			RIB ASSY, 350 BASKET	NTS
DATE	10.03.04		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

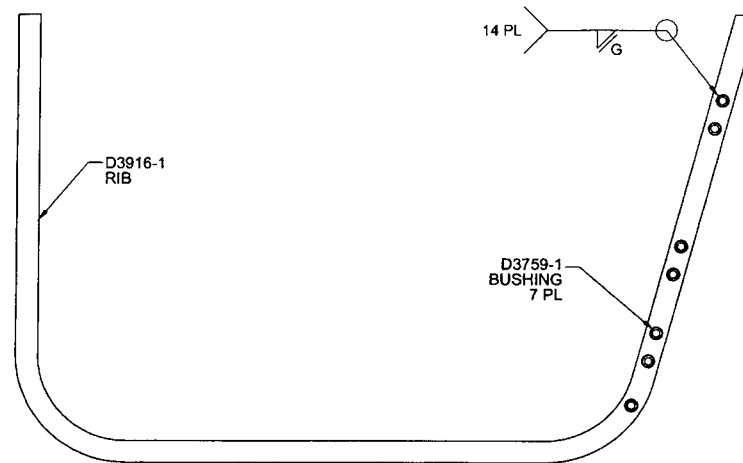
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



77142



**D3916-041 RIB ASSY**

**RELEASED**  
2010-03-12  
AMP

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
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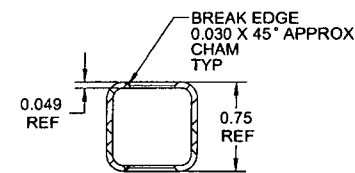
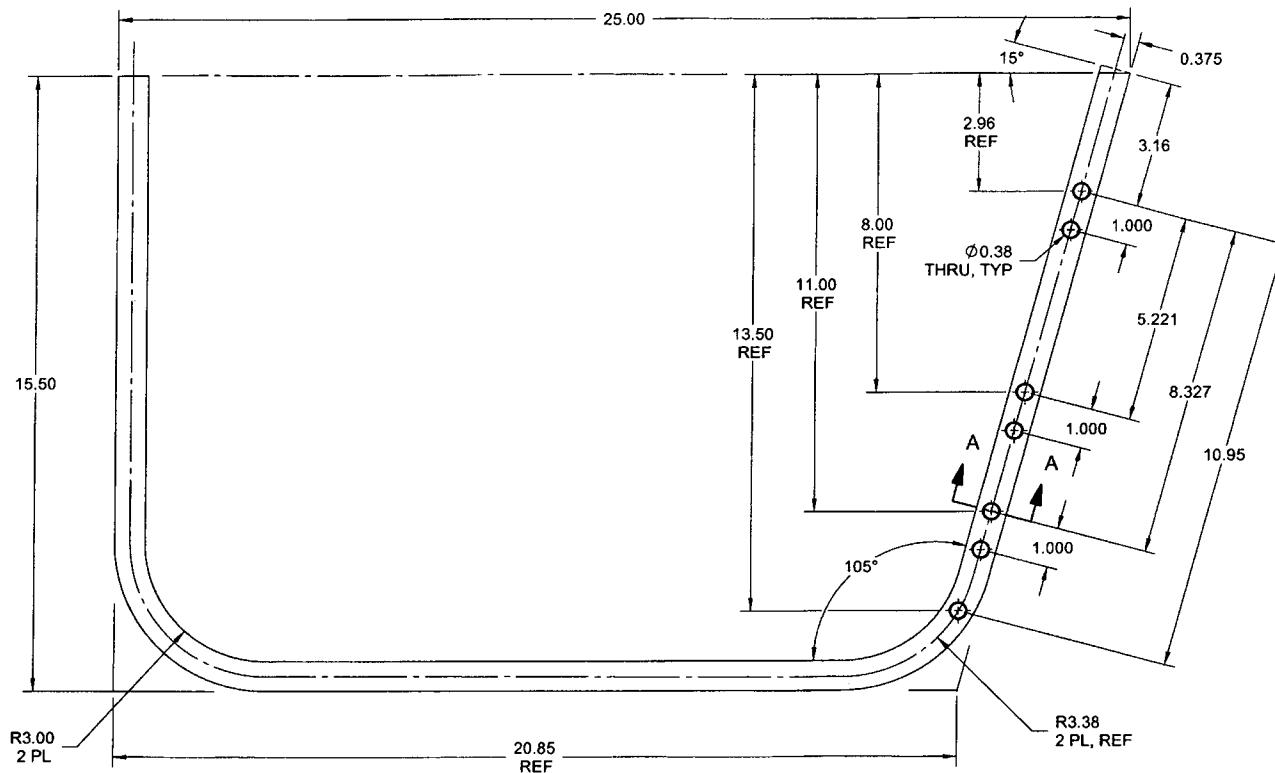
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NOTE: Date & initial all entries

77142



SECTION A-A

9 D3916-1 RIB

**RELEASED**  
2010-03-12  
JPH

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

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CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3916</b>	REV. A SHEET 3 OF 4
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DATE	10.03.04		

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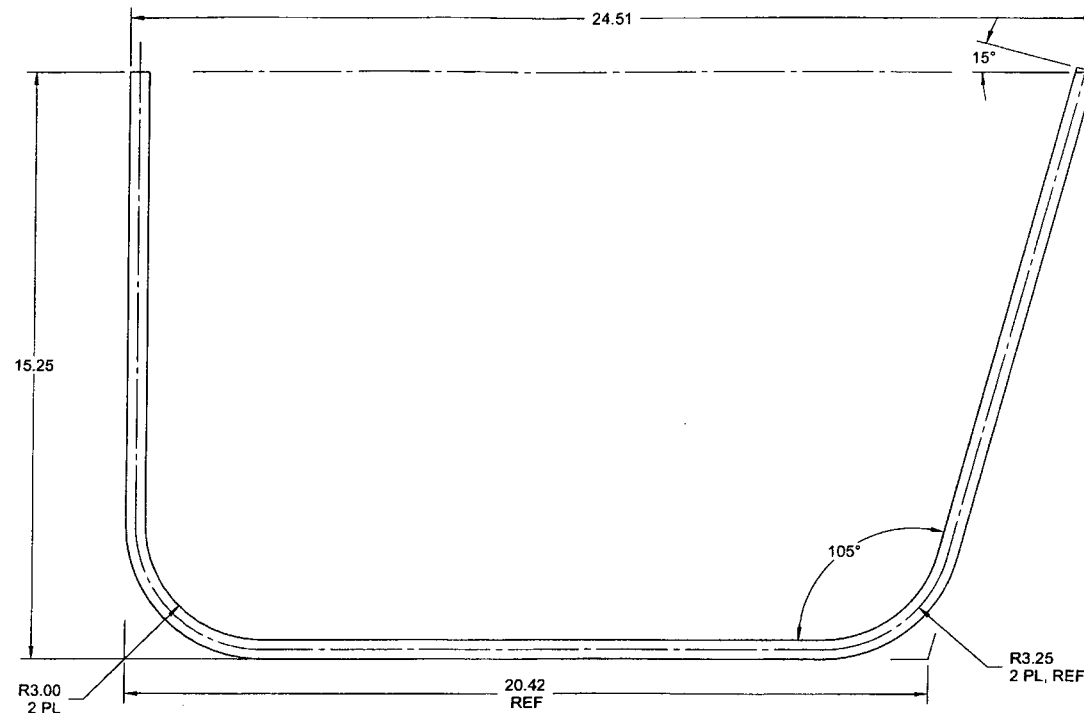
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NOTE: Date & initial all entries

77142



9 D3916-5 LIGHT RIB

**RELEASED**  
2010-03-12  
JM

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916	REV. A SHEET 4 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE RIB ASSY, 350 BASKET	SCALE NTS
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DE APPR.	<i>[Signature]</i>		
DATE	10.03.04		

Dart Aerospace Ltd

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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